

Work Order ID 149048

July 19, 2016 11:43:56 AM

149048

Page 1

Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 7/19/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/20/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference: RE-INSPECT

Approvals: Process Plan: SH Date: 7/19/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

DAS
21
9-89
JUL 19 2016

100 Document Control 0.00
100
 DC DOCUMENT CONTROL
 Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile and type labels as per PPP D350-591-311 CHG001 NOW FOR AIRBUS

102 0.00
102
 Production Memo 0.00
 Production (Internal) PULL D350-591-311 QTY 1 B144849 FROM STOCK

105 0.00
105
 QC Memo 0.00
 Quality Control RE-INSPECT STEP AND KIT ENTIRELY
 NOW HAS TO SHIP TO AIRBUS

SmB
16/19

Q 1607-20 20

DART aerospace		1270 ABERDEEN ST HAWKESBURY, ON CANADA K6A 1K7 TEL: 1-813-632-5200 www.dartac.com	
PATENT	N/A		
P/N	D350-591-311	CHG	CHG002
DESC	Heli-Access Step LH High	SC	SH92-6
LOT	B144849	SC	SH967NE
MODEL	AS350/355	SC	
TC APPROVAL #09-89		MADE IN CANADA	
		027294	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 149048***149048***

Page 2

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 7/19/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/20/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference: RE-INSPECT

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

107

Pick Kit

0.00

107

Packaging

Memo

0.00

Packaging

RE-PACKAGE AS PER AIRBUS SHIPPING REQUIREMENTS

USE NEW BATCH NUMBER FOR IDENTIFICATION

ENSURE DSI 9410-011 X 1 IS REMOVED

SMB
16/7/19

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.01

Quality Control

SMB
16/7/19

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311
Location : FG084SMB
16/7/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : _____																	

Work Order ID 149048***149048***

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July 19, 2016 11:43:56 AM

Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 7/19/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/20/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference: RE-INSPECT

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.02

Quality Control

DAS
21
9-89

JUL 19 2016

DAS
21
9-89

JUL 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

July 19, 2016 10:54:03 AM

Page 1

Work Order ID: 149048

149048

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 7/19/2016

Required Date: 7/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D350-591-311		Manufactured	No				Each	0.0000		1			
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D350-591-311

Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

**

DAS
27
9:09

JUL 20 2016

B144849

Picklist Print

Thursday, May 19, 2016 1:41:20 PM

Page 3

Work Order ID: 144849

144849

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/1/2016

Required Date: 6/17/2016

Start Qty: 5.00

Required Qty: 5.00

AN3-35A

Purchased No

250

Each

127.0000

2

10

AN3-35A

Bolt

**

DAG 6 27 9-89

DAS 28 9-89

DAS 28

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

117

m134167

50

m134497

67

D3235-1

Manufactured No

250

Each

80.0000

2

10

D3235-1

Mounting Lug

**

DAG 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST521

30

143809

30

ST546A

50

142565

50

D3278-041

Manufactured No

250

Each

28.0000

1

5

D3278-041

Support Assembly

**

DAG 6 27 9-89

DAS 28 9-89

Location

Loc Qty

Loc Code

ST522

28

145580

28

MAY 31 2016

Thursday, May 19, 2016 1:41:20 PM

Shop Packet Print

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Picklist Print

Thursday, May 19, 2016 1:41:20 PM

Page 4

Work Order ID: 144849

144849

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/1/2016

Required Date: 6/17/2016

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

250

Each

3,255.000

16

80

6

8-89

NAS1149D0463.I

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

146

M132035

21

M134508

125

ST260a

2600

M134754

2600

ST263

509

M134634

509

NAS1149D0563J

Purchased

No

250

Each

1,092.000

4

20

6

8-89

NAS1149D0563.I

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

237

m125807

2

m133769

235

ST263

756

m134497

756

ST269

99

m128257

99

AN5-36A

Purchased

No

250

Each

57.0000

2

10

6

8-89

AN5-36A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST336

57

M130466

15

M134509

2

M134676

40

MAY 31 2016

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Page 4

Picklist Print

Page 5

Thursday, May 19, 2016 1:41:20 PM

Work Order ID: 144849

144849

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/1/2016

Required Date: 6/17/2016

Start Qty: 5.00

Required Qty: 5.00

D2618

Manufactured No

250

Each

51.0000

2

10

DAS

6

DAS

27

D2618

Bushing

DAS

28

9-89

Location

Loc Qty

Loc Code

ST008A

51

144670

51

2

D2230-3

Manufactured No

250

Each

193.0000

4

20

DAS

6

DAS

27

D2230-3

Mounting Lug

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

5

141406

1

142522

4

ST525A

180

143805

100

144487

80

D2856-400-720

Manufactured No

250

Each

169.0000

2

10

D2856-400-720

Abrasion Strip 4" X 7.20"

Location

Loc Qty

Loc Code

FG

14

134509

4

137049

10

ST418

155

141946

5

146220

150

DAS

28

9-89

DAS

6

27

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Shop Packet Print

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Picklist Print

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Page 6

Work Order ID: 144849

144849

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/1/2016

Required Date: 6/17/2016

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

250

Each

1.633.000

2

10

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

254

m133790

3

m134360

251

ST303

1279

m134039

12

m134360

67

m134634

600

m134754

600

AN4-13A

Purchased

No

250

Each

325.0000

8

40

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

60

m134167

36

m134634

24

O003

200

m134754

200

ST344

45

m134634

45

DAS
28
9-89

DAS
6 28
9-89 27
9-89

MAY 31 2016

Thursday, May 19, 2016 1:41:20 PM

Shop Packet Print

Page 6

Picklist Print

Thursday, May 19, 2016 1:41:20 PM

Page 1

Work Order ID: 144849

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/1/2016

Required Date: 6/17/2016

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified

by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1

D3272-1

Step

Manufactured No

110

Each

5.0000

1

5

**

BE 16-05-19

Location

WA003

140462

144997

Loc Qty

5
2
3

Loc Code

2
3
3

D3067-1

D3067-1

End Plate

Manufactured No

110

Each

25.0000

1

5

**

BE 16-05-19

Location

WA003

142780

Loc Qty

25
25

Loc Code

5
10

D3219-1

D3219-1

Plate

Manufactured No

110

Each

80.0000

2

10

**

BE 16-05-19

Location

WA003

142668

144410

Loc Qty

80
40
40

Loc Code

10
40

D51 910-041 x 2 B 146991

DAS
27
9-89

2 B B147063

DAS
28
9-89

Y4

Picklist Print

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Work Order ID: 144849

144849

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 6/1/2016

Required Date: 6/17/2016

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0363J

Purchased

No

250

Each

1,814.000

4

20

NAS1149D0363.I

Washer

**

DAS

28

9.89

DAS

27

9.89

MAY 31 2016

DAS
28
9.89

Location

Loc Qty

Loc Code

GA

480

m134055

480

ST260a

1000

m134676

1000

ST263

334

m134606

334

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Shop Packet Print

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